-015

Dart Aerospace Ltd.

3

Date: Wednesday, 11/21/2007 12:45:06 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 35908A		
Estimate Number	: 12520		
P.O. Number	:	Part Number	: D205634~~05~~-041
This Issue	: 11/21/2007 S.O. No. :	Drawing Number	: D2580 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 35907A	Material	:
Written By	:	Due Date	: 1/15/2008 Qty: 1 Um: Each
Checked & Approved By	: 07.11.21		
Comment	: Est Rev:C Revised Steps 06-09-06 JLM		
	Est Rev:D Added SS Wearplates & Gaskets 07-07-09 JLM		

07-12-07 Rev NCR 271

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

00616e

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634-~~045~~ -041 CHG002 N/A

2.0	D25001190	Ext'n - 'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	3429 SL 7-11-27

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	35996 SL 7-11-27

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

7-11-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35908A **Part Number:** D2056340~~45~~ -~~SP~~

Job Number:

Seq. #:	Machine Or Operation:	Description :

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

SL 7-11-27

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R		Sikaflex-291	103488

Sikaflex expire date: 8-7-1

Start Time: 3:00 Date: 7-11-27

Fin Time: 9:00 Date: 7-12-13

SL 7-11-27

5.0	BENDING	BENDING MACHINE	

Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/SR 7-11-28

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

BE 07-12-13

N/A ~~2-Drill extra fwd hole as per DEO 9183 using drill jig DT8461~~

N/A ~~3-Drill extra middle hole as per DEO 9183 using drill jig DT8462~~

4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN TO FINISH SIZE*** BE 07-12-13

N/A ~~5-Drill extra aft holes as per DEO 9183 using drill jig DT8463 locating from aft cap hole and aft saddle hole.~~

7.0	QC5	INSPECT WORK TO CURRENT STEP	PTO

Comment: INSPECT WORK TO CURRENT STEP BE 07-12-13

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
07.12.07	5.0	Aft end cut too short. See NCR 271 R.C.: Human error	QS1442	- Fabricate 6061-T6 plug 0.D.502x.157 m105671 Qty 4, from R.B - Plug DEO 9183 holes and weld per QS1004. Rod m 1006035 AIR grind flush.	BE 07-12-12 BE 07-12-12	07/12/21 07/12/21	QS1442	07-12-07

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35908A **Part Number:** D205634~~5~~ -091

Job Number:

Seq. #:	Machine Or Operation:	Description :
8.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	D-33464 BE 07-12-13

9.0	D2579	Crossbolt Spacer

Comment: Qty.: ~~24~~.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: 20

Qty	Part Number	Description	Batch
20 ~~24~~	D2579	Spacers	B34789 BE 07-12-13

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 07-12-13

2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod m106035 BE 07-12-13

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod m106035 BE 07-12-13

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending VI 7-12-19

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes
~~**********DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384Ø AS PER DEO 9183)**********~~

7-Open aft cap holes to #6 Drill bit. Deburr SL 7-12-20

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35908A **Part Number:** D205634~~045~~ -041

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 07-12-20 (1)
12.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/12/21 (1)
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Pressure wash as per QSI 005	FL 07/12/27 (1)
14.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat ~~****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3~~	Powder coat white per QSI 005 4.3.5.1 A.M 07.12.27 (1)
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	FL 07/12/28 (1)
16.0	D2855	Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cap Batch: B34349	FL
17.0	AN35A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Batch: M100188	FL
18.0	AN960JD10L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer Batch: M104374	FL 07/12/28 (1)

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W/O:		WORK ORDER CHANGES						
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35908A **Part Number:** D205634~~045~~ -041

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	ALS71032130	Insert

Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)
Insert
Batch: M105729 FL

20.0	AN3C4A	BOLT

Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)
BOLT
Batch: M106277 FL

21.0	D356613	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: [redacted] B32744 FL

22.0	D35665	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B34354 FL

23.0	D35661	GASKET

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
Batch: B35788 (x1) B36280 (x1) FL

24.0	D356413	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B33456 FL

25.0	D356411	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B34805 FL 07/12/28

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
07/12/28	20:1	AN960C10L Qty: 50 Batch: m106578 FL 07/12/28	[illegible]				08/1/08

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35908A **Part Number:** D205634~~05~~ -041

Job Number:

Seq. #:	Machine Or Operation:	Description :
26.0	D35649	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 034807 FL

27.0	D35645	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 036111 FL

28.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: 027168 FL

29.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: 033450 FL

30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M105585
Sikaflex expire date: 08-07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 M105585
Sikaflex expire date: 08-07

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch:
M106332 a.m 07.08.03

FL 07/12/28 (9)

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35908A **Part Number:** D205634~~045~~ -041

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	QC5	INSPECT WORK TO CURRENT STEP 08/01/09 (V)

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-~~045~~ -041
Location:
PPP Rev: H

33.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

11.12.07

QC84 08/01/08

08.01.09

35908A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2580	SHEET 1 OF 3
DATE		TITLE	SCALE
07.02.27		205 SKIDTUBE ASSEMBLY	NTS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED
07 06 28

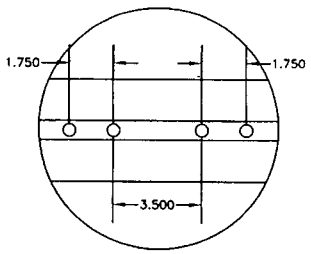
QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL ∅0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

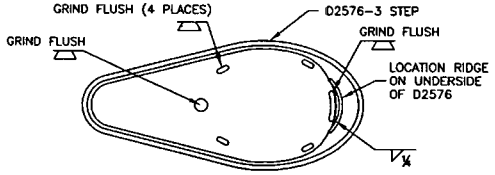
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35908 A

DETAIL A
SCALE 5:24

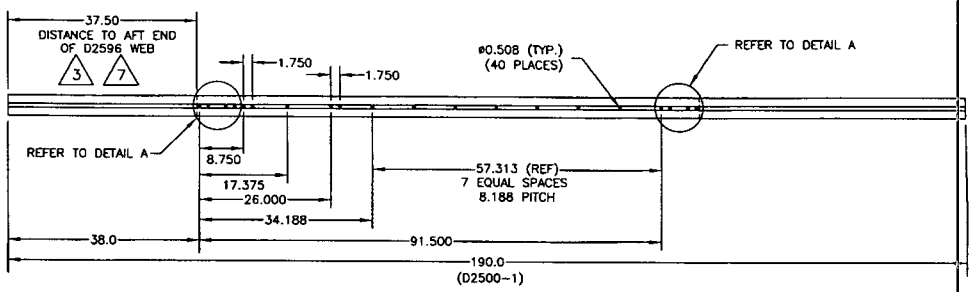


RELEASED
07.02.28

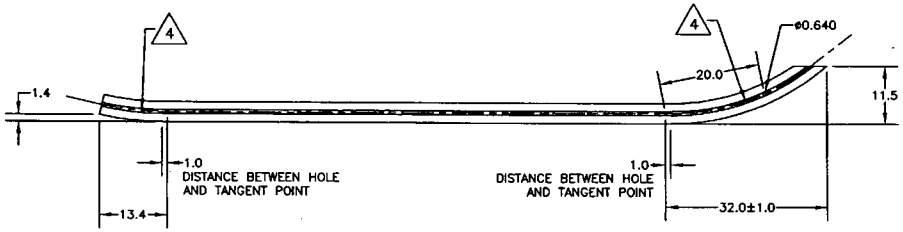
DETAIL B
SCALE 5:24



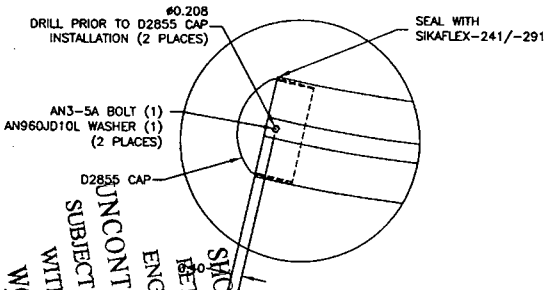
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



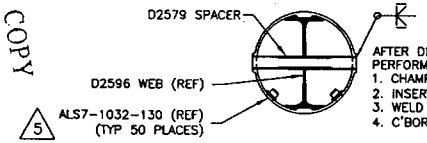
DETAIL C
SCALE 5:24



UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE

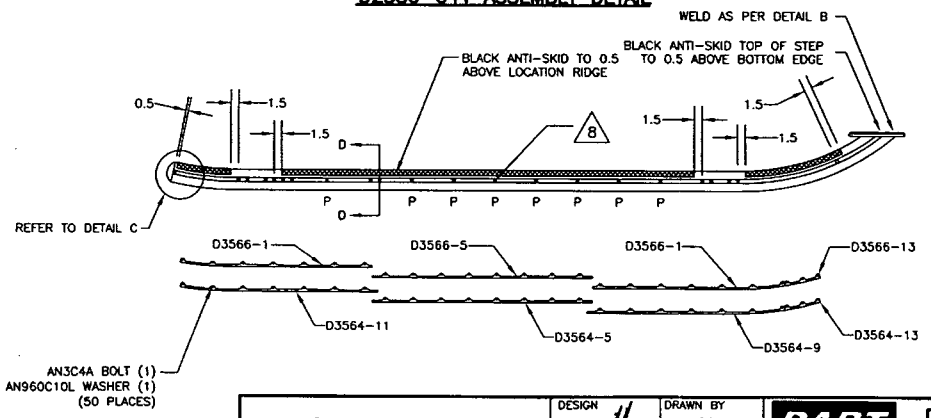
WORK ORDER NO. 25208 A

SECTION D-D
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

D2580-041 ASSEMBLY DETAIL

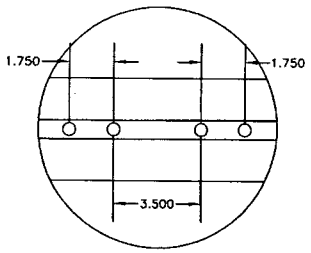


D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

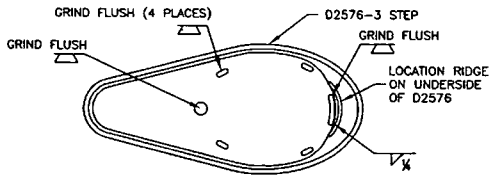
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SHEET 2 OF 3
			SCALE 1:24

DETAIL E
SCALE 5:24

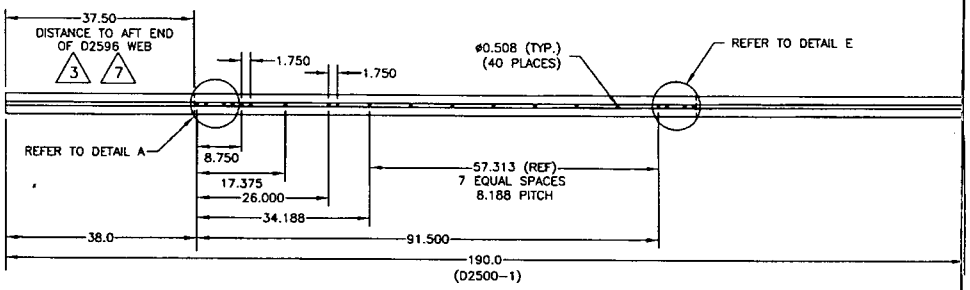


RELEASED
07 de 28

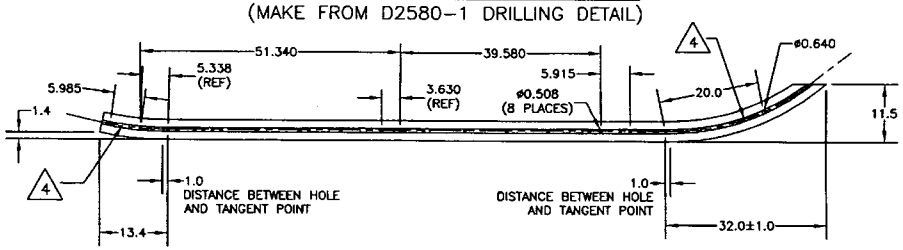
DETAIL F
SCALE 5:24



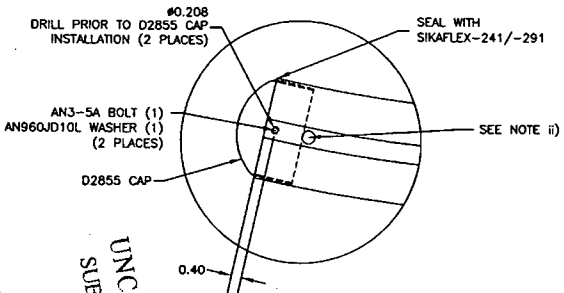
D2580-1 DRILLING DETAIL



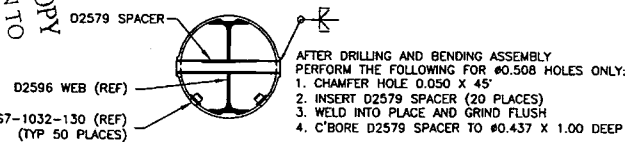
D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



DETAIL G
SCALE 5:24

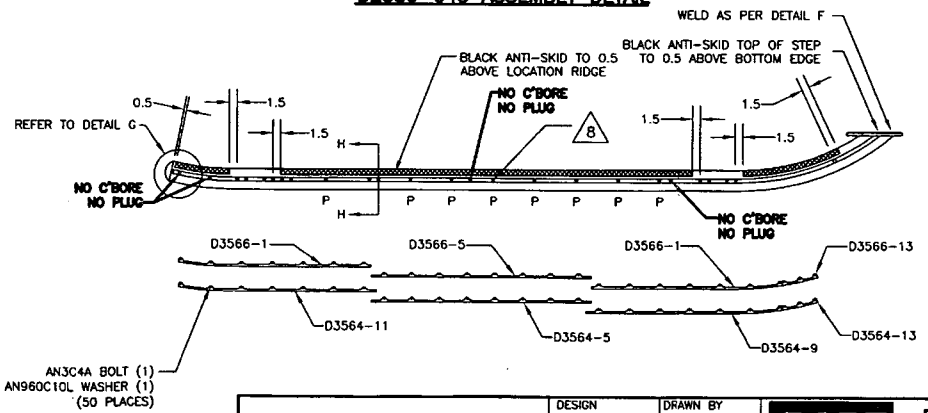


SECTION H-H
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

D2580-045 ASSEMBLY DETAIL



c

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
RH	RH	
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D
		SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24

NO. 133

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure tig
Part number and Job number D205 631 041 / B35642

TEST WELDS REQUIRED

BASE METAL Aluminium
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS tig
Single Weld [✓] **Double Weld** [ ]
Backing YES [ ] NO [✓]

Position **Vertical** Down [ ] Up [ ]

Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [✓]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [✓]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-11-27 **Qualifier** Ed Dw